

Work Order ID 61935

PRELIMINARY ISSUE

Friday, September 10, 2010 9:14:47 AM

Page 1

Item ID: D4172-043

Accept

Revision ID: PRELIM

Item Name: Z-Shape Section Assembly, LH

Setup Start

Stop

Start Date: 9/10/2010 Start Qty: 1.00

Required Date: 9/17/2010 Req'd Qty: 1.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-9-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4172

PA2

10.09.16

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Transfer drill holes, deburr and assemble as per dwg

RT 10-09-21

(P40)

110

QC5- Inspect part completeness to step on W/O

0.00 - inspect up to PA2



QC

Memo

0.00

Quality Control

Dwg only

8/10/12 (P40)

120

Identify as per dwg & Stock Location: composites

0.00



Packaging

Memo

0.00

Packaging

RT 10-09-21

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10-09-22	100	rivets along angled top piece installed facing outward non permanent change ACCEPTABLE 10-09-22	BT	10-09-22	1	10-09-22	10/09/22

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10-09-22	100	3 rivets not sorted well		remove or install 3 new rivets of 3243 4-04 m 104291 ulq8	10-09-22			

NOTE: Date & initial all entries

Work Order ID 61935

Friday, September 10, 2010 9:14:47 AM



Page 2

Item ID: D4172-043

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Z-Shape Section Assembly, LH

Start Date: 9/10/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 9/17/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/09/29
m
10-9-23

POSITIVE RECALL

EFFECTIVE 09/13 AUTH 4

RELEASED

DATE 10/09/29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Friday, September 10, 2010 9:14:52 AM

Page 1

Work Order ID: 61935

Parent Item: D4172-043

Parent Item Name: Z-Shape Section Assembly, LH













Start Date: 9/10/2010

Required Date: 9/17/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 10.09.09 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4172-1 		Manufactured	No			100	Each	0.0000	1	1			
Supporting Plate						B61938					RT	10-09-21	
D4172-3 		Manufactured	No			100	Each	0.0000	1	1			
Support Angle						B61940 B61939					RT	10-09-21	
D4172-15 <i>as per DWG D4172</i> 		Manufactured	No			100	Each	0.0000	1	1			
Support Angle						B61941					RT	10-09-21	
CR3213-4-04 		Purchased	No			100	Each	0.0000	46	46			
Rivet						B104291					RT	10-09-21	
MS20426AD3-15 <i>10.09.21</i> 		Purchased	No			100	Each	6,540.000	22	22			
RIVET						104 m4179					RT	10-09-21	
<div> <div>Location</div> <div>ST316</div> <div>204374 110398</div> </div> <div> <div>Loc Qty</div> <div>6540</div> <div>2540</div> <div>4000</div> </div> <div> <div>Loc Code</div> <div>1122</div> </div>													
MS21075L4 <i>CR MS21075L4N 10.09.21</i> 		Purchased	No			100	Each	0.0000	11	11			
Nutplate						115708					RT	10-09-21	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

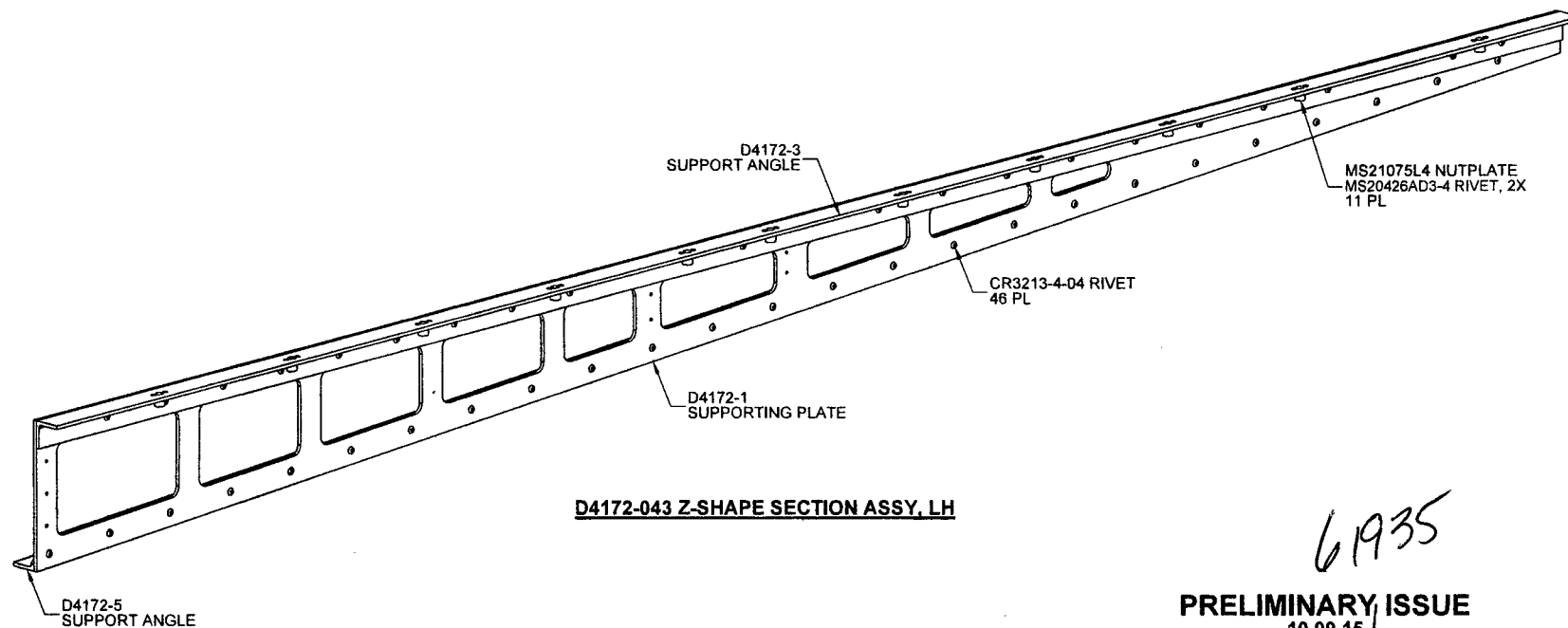
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY	P/N	DESCRIPTION
	X	D4172-043	Z-SHAPE SECTION ASSY, LH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-3	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-4	RIVET
6	11	MS21075L4	NUT PLATE

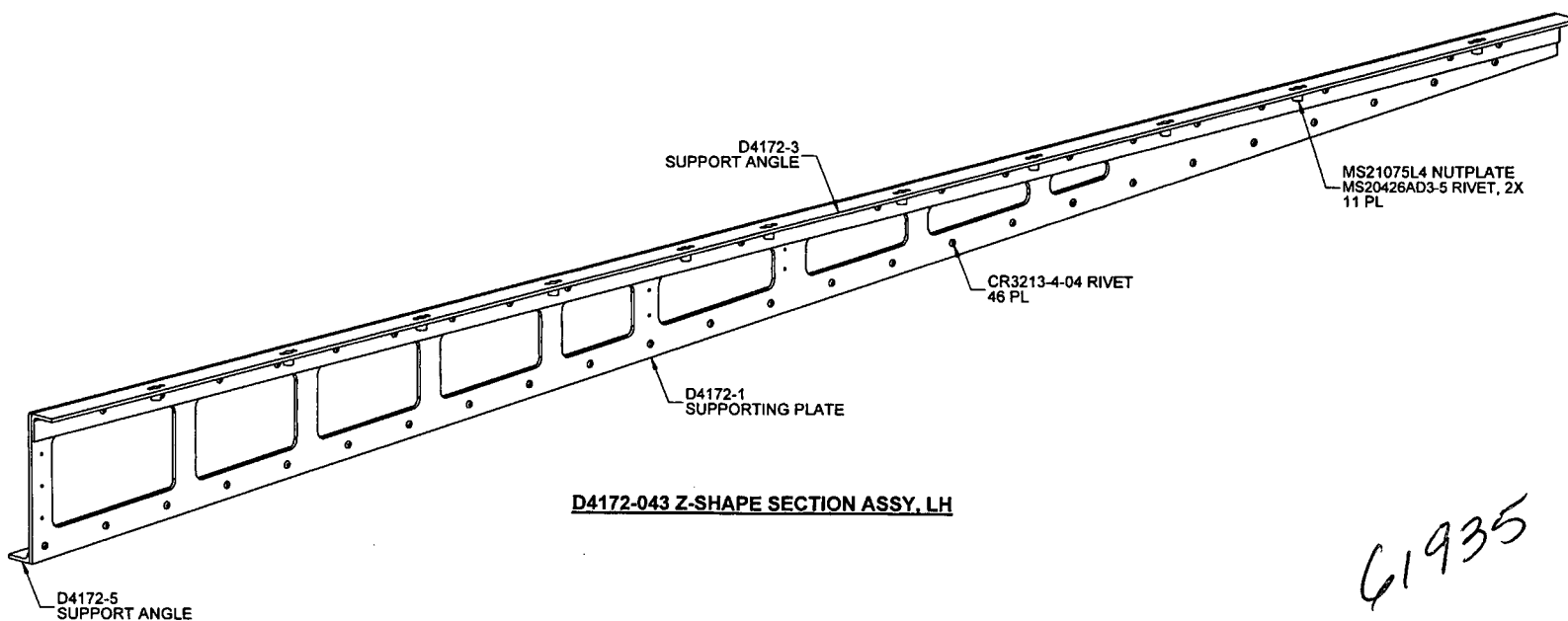


PRELIMINARY ISSUE
10.09.15

NOTES:
1) MATERIAL: NONE
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 2.13 lbs

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO. D4172
MFG. APPR.		REV. PA2
APPROVED		SHEET 2 OF 7
DE APPR.		TITLE POD MOUNTING FRAME ASSY
DATE	10.09.15	SCALE NTS
<small>COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>		

ITEM	QTY -043	P/N	DESCRIPTION
	X	D4172-043	Z-SHAPE SECTION ASSY, LH
1	1	D4172-1	SUPPORTING PLATE
2	1	D4172-3	SUPPORT ANGLE
3	1	D4172-5	SUPPORT ANGLE
4	46	CR3213-4-04	RIVET
5	22	MS20426AD3-5	RIVET
6	11	MS21075L4	NUT PLATE



D4172-043 Z-SHAPE SECTION ASSY, LH

NOTES:
 1) MATERIAL: NONE
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 2.13 lbs

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4172	SHEET 2 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	POD MOUNTING FRAME ASSY	NTS
DATE	10.09.15	COPYRIGHT © 2010 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

61935

RELEASED
 2010-09-28